

Amendments to the Claims:

Please cancel Claim 6 without prejudice to or disclaimer of the subject matter contained therein.

Please amend Claims 1, 3-5, 7 and 8 as follows.

1. **(Currently Amended)** A manufacturing method for a toner container provided with an opening, said method comprising:

a filling step of filling the toner container with toner through an opening;

a closing step of setting a ~~cap~~ cover member and closing the opening with the ~~cap~~ cover member, after said filling step; and

a sealing step of sealing the opening after said closing step, by ~~vibration~~ ultrasonic welding of the ~~cap~~ cover member to the toner container by a welding jig member,

said welding member is contacted to a part of a welding region between said cover member and said container to import ultrasonic vibration, and

wherein the ~~cap~~ cover member is welded to the toner container while imparting a relative movement of the welding jig member relative to the toner container toward an ~~un-~~ welded unwelded portion.

2. **(Previously Presented)** A method according to Claim 1, further comprising a fixing step of fixing a position of the toner container and substantially preventing movement of the toner container, wherein said filling step is effected after said fixing step.

3. **(Currently Amended)** A method according to Claim 2, wherein the relative movement is provided by moving the welding jig member.

4. **(Currently Amended)** A method according to ~~anyone~~ any one of Claims 1-3, further comprising a pressing step of pressing the ~~cap~~ cover member into the toner container by a pressing jig member after the ~~cap~~ cover member is set in the toner container in said closing step.

5. **(Currently Amended)** A method according to Claim 4, wherein said sealing step is effected after the ~~cap~~ cover member is pressed into the toner container in said pressing step.

6. **(Cancelled)**

7. **(Currently Amended)** A method according to Claim 1, wherein in said sealing step, the welding jig member is circulated around the opening to return to a start point of welding.

8. **(Currently Amended)** A method according to Claim 1, wherein the welding jig member has a projected free end.

9. **(Previously Presented)** A method according to Claim 1, wherein the opening functions to permit removal of a mold during injection molding of the toner container.

10. **(Withdrawn)** A toner container detachably mountable to an image forming apparatus, said toner container comprising:

a container body;

an opening provided in said container body; and

a cap member for closing said opening,

wherein said cap member is welded to the toner container while imparting a relative movement of a welding jig relative to said container body toward an unwelded portion to seal said opening by vibration welding of said cap member to said container body using the welding jig after filling the toner into said container body through said opening.

11. **(Withdrawn)** A toner container according to Claim 10, wherein said opening accepts accept filling toner with a position of the toner container being substantially immovably fixed.

12. **(Withdrawn)** A toner container according to Claim 11, wherein said cap member is welded to the toner container by moving the welding jig.

13. **(Withdrawn)** A toner container according to any one of Claims 10-12, wherein said cap member is welded while a pressing jig presses said cap member.

14. **(Withdrawn)** A toner container according to Claim 10, wherein said cap member is ultrasonic-welded to the toner container by the welding jig.

15. **(Withdrawn)** A toner container according to Claim 10, wherein said cap member is welded while the welding jig is circulated around said opening to return to a start point of welding.

16. **(Withdrawn)** A toner container according to Claim 10, wherein said cap member is welded by the welding jig having a projected free end.

17. **(Withdrawn)** An apparatus according to Claim 10, wherein said opening functions to permit removal of a mold during injection molding of the toner container.